Date: Tuesday, 4/24/2007 3:15:12 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHROUD ASSEMBLY
Job Number	: 32033		
Estimate Number	: 12226		
P.O. Number	: N/A	Part Number	: D3467041
This Issue	: 4/24/2007 S.O. No. : N/A	Drawing Number	: D3467 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 28536	Material	: N/A
Written By	:	Due Date	: 5/8/2007 Qty: ~~2~~ 1 Um: Each
Checked & Approved By	: 07.04.25		
Comment	: Est Rev: A New Issue 06-04.24 JLM Est Rev:B As per Rev B 06-05-24 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D3467043	FWD PLATE ASSEMBLY

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3467-043	Fwd Plate Ass	B26947

Seq. #:	Machine Or Operation:	Description :
2.0	D3467045	BAFFLE & DEFLECTOR ASSEMBLY

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3467-045	BAFFLE & DEFLECTOR ASSEMBLY	~~[illegible]~~ B32039

Seq. #:	Machine Or Operation:	Description :
3.0	D3467047	COVER PLATE ASSEMBLY, LH

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3467-047	cover lh	B24554

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/24/2007 3:15:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SHROUD ASSEMBLY

Job Number: 32033 **Part Number:** D3467041

Job Number:

Seq. #:	Machine Or Operation:	Description :
4.0	D3467048	COVER PLATE ASSEMBLY, RH

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3467-048	cover rh	B24555

Seq. #:	Machine Or Operation:	Description :
5.0	NAS679A3	NUT SELF LOCK

Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
8	NAS679A3	Nut	M100651

Seq. #:	Machine Or Operation:	Description :
6.0	AN96010	Washer

Comment: Qty.: 18.0000 Each(s)/Unit Total : 36.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
18	AN960-10	Washer	M5519

Seq. #:	Machine Or Operation:	Description :
7.0	AN33A	Bolt

Comment: Qty.: 18.0000 Each(s)/Unit Total : 36.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
18	AN3-3A	Bolt	M103962

Seq. #:	Machine Or Operation:	Description :
8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467 [signature] 07-05-01 (1)

Seq. #:	Machine Or Operation:	Description :
9.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP SB 07/05/01 (1)

Seq. #:	Machine Or Operation:	Description :
10.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify with fine point marker and Stock
Location:_______ [signature] 07-05-01 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** ______ **Fault Category:** ______________ **NCR:** Yes / No (No circled) **DQA:** [signature] **Date:** 07/05/02

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD ASSEMBLY

Job Number: 32033

Part Number: D3467041

Job Number:

Seq. #:	Machine Or Operation:	Description :
11.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

07/05/02

Job Completion

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** _______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** _________

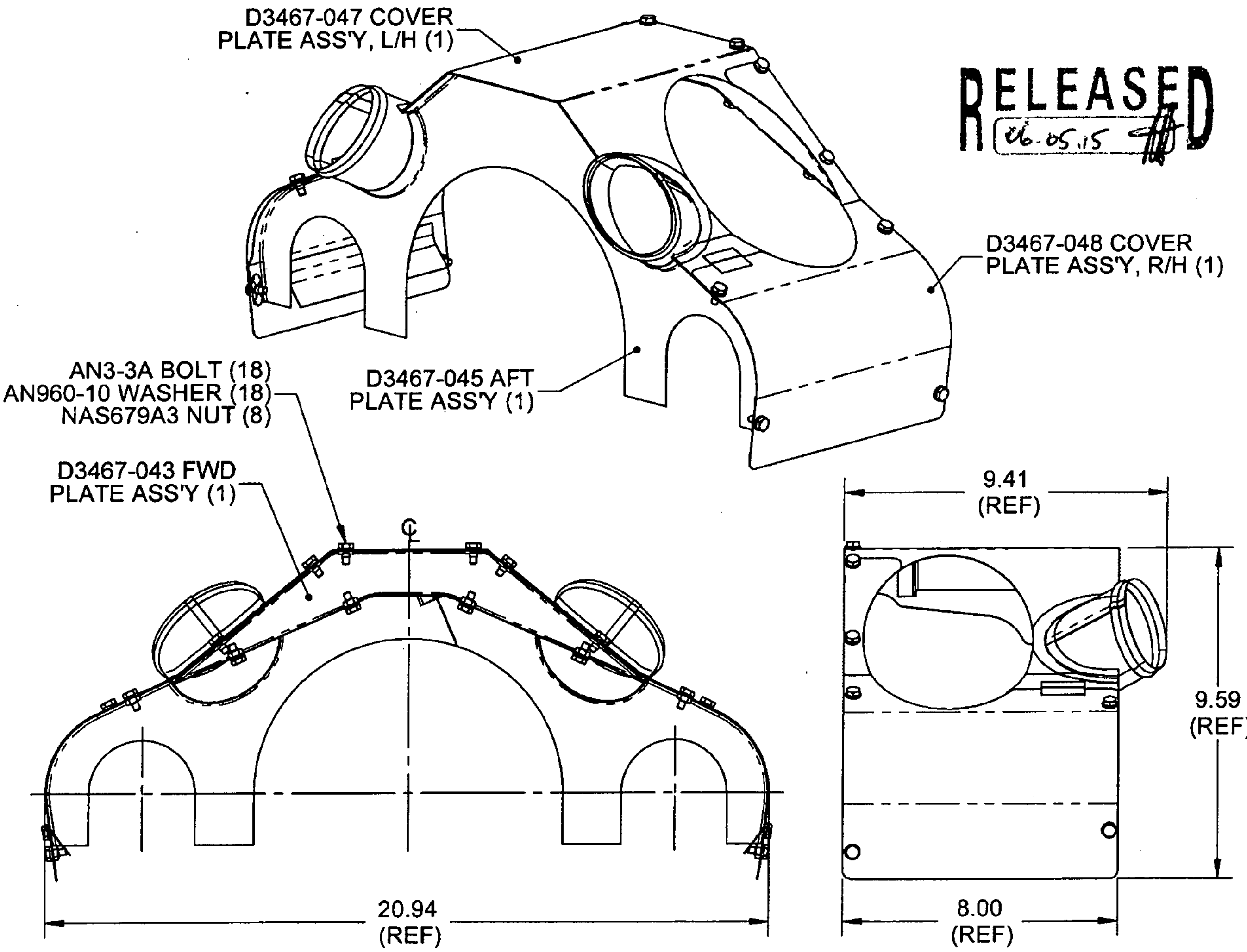
QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3467 — REV. B — SHEET 1 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY — SCALE 1:5

A	05.12.07	NEW ISSUE
B	06.05.15	Ø0.250 & Ø0.203 WERE Ø0.194 ; UPDATED D3467-9F/-15F



D3467-041 SHROUD ASSEMBLY

QTY -041	P/N	DESCRIPTION
X	**D3467-041**	**SHROUD ASSEMBLY**
1	D3467-043	FWD PLATE ASSEMBLY
1	D3467-045	AFT PLATE ASSEMBLY
1	D3467-047	COVER PLATE ASSEMBLY, L/H
1	D3467-048	COVER PLATE ASSEMBLY, R/H
18	AN3-3A	BOLT
18	AN960-10	WASHER
8	NAS679A3	NUT

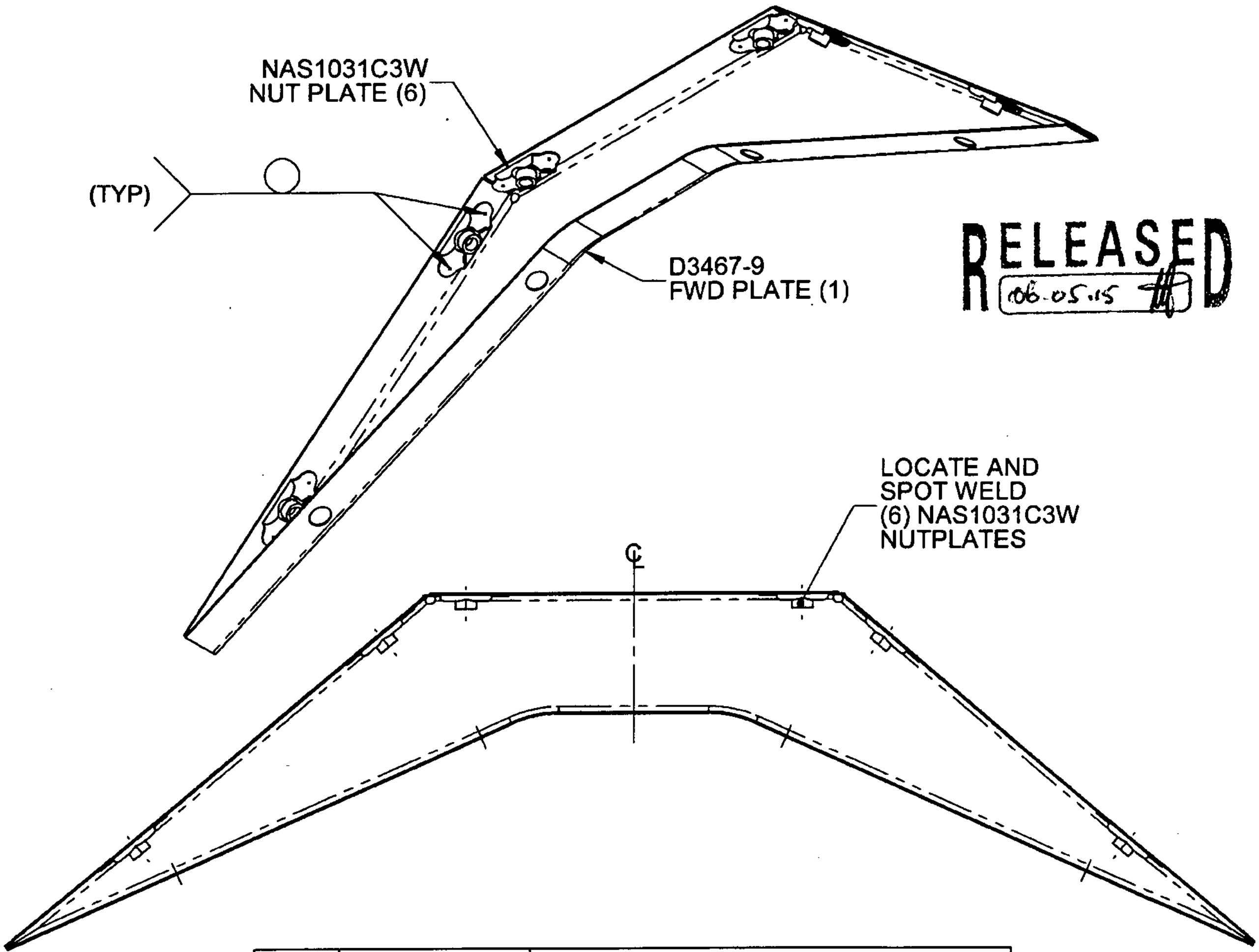
SHOP COPY RETURN TO ENGINEERING
UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 32033

NOTES:

1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
3) FINISH: NONE
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3467 — REV. B — SHEET 2 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY — SCALE 1:2

DART



RELEASED 06.05.15

QTY -043	P/N	DESCRIPTION
X	**D3467-043**	**FWD PLATE ASSEMBLY**
1	D3467-9	FWD PLATE
6	NAS1031C3W	NUT PLATE

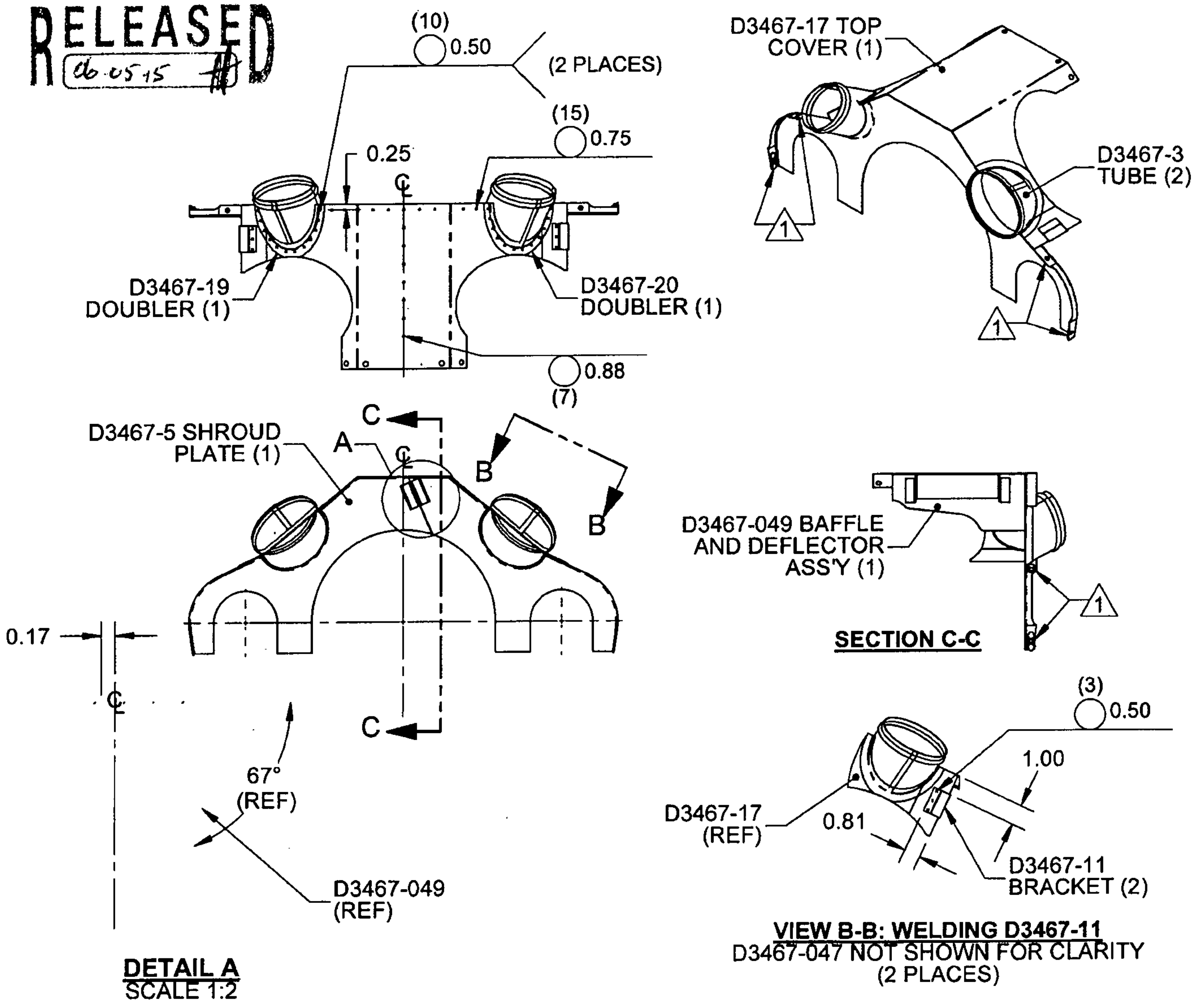
D3467-043 FWD PLATE ASSEMBLY

NOTES:

1) SPOT WELD PER DART QSI 004
2) FINISH: NONE
3) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3467	REV. B SHEET 3 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:8

DART



D3467-045 AFT PLATE ASSEMBLY

NOTES:

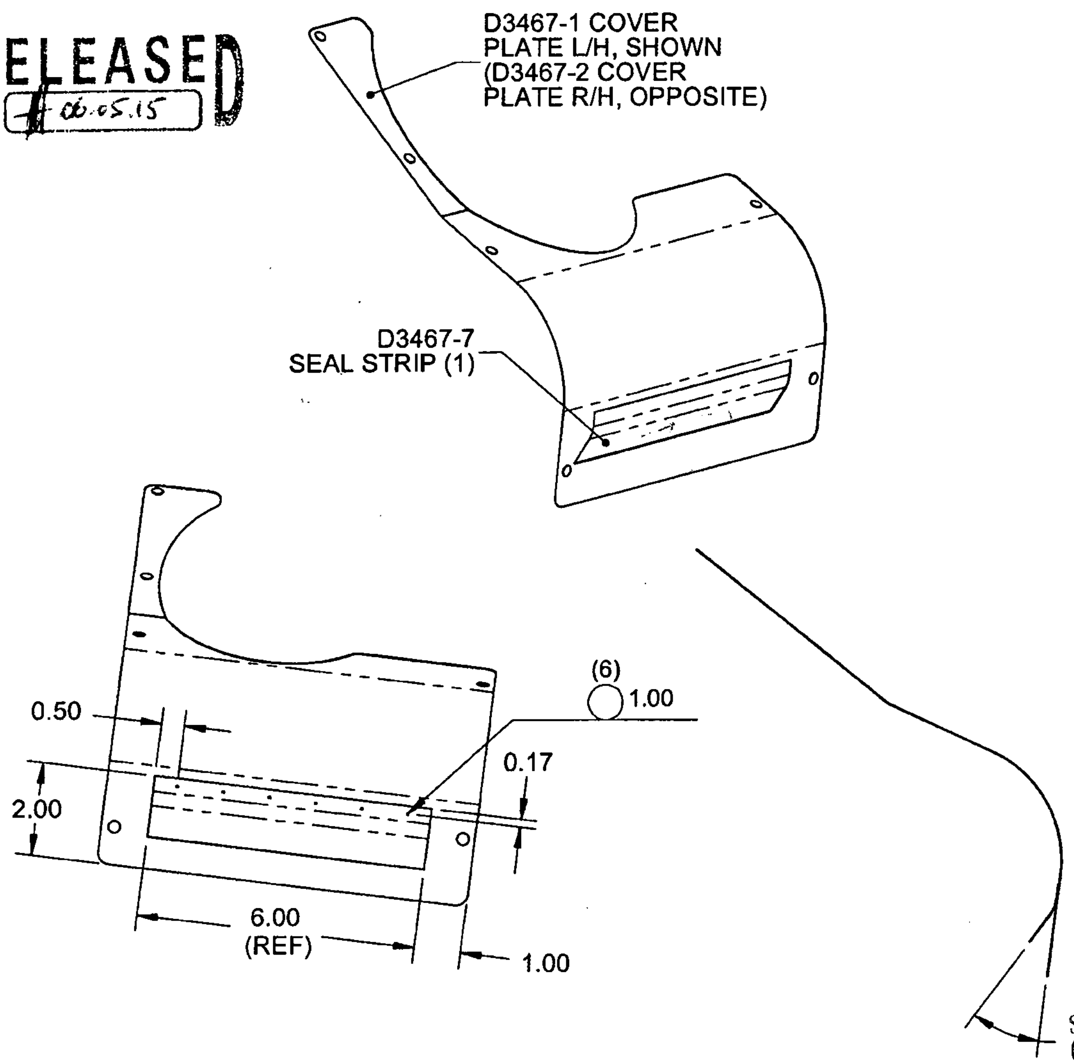
1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
2) SPOT WELD PER DART QSI 004
3) FINISH: NONE
4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES
7) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -045	P/N	DESCRIPTION
X	**D3467-045**	**AFT PLATE ASSEMBLY**
1	D3467-049	BAFFLE AND DEFLECTOR ASSEMBLY
2	D3467-3	TUBE
1	D3467-5	SHROUD PLATE
2	D3467-11	BRACKET
1	D3467-17	TOP COVER
1	D3467-19	DOUBLER
1	D3467-20	DOUBLER
4	NAS1031C3W	NUT PLATE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3467	REV. B SHEET 4 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

DART

RELEASED 06.05.15



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WORK ORDER NO. 32032

D3467-047 COVER PLATE ASS'Y L/H, SHOWN
D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE

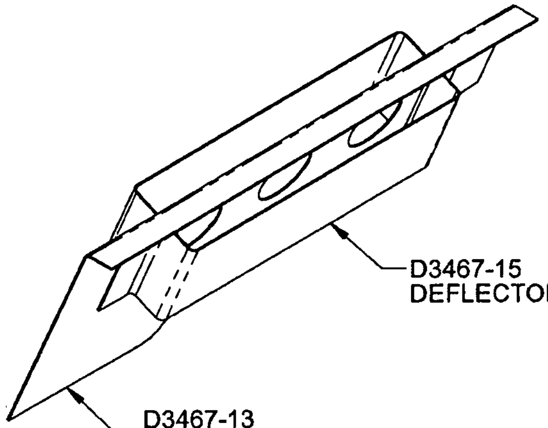
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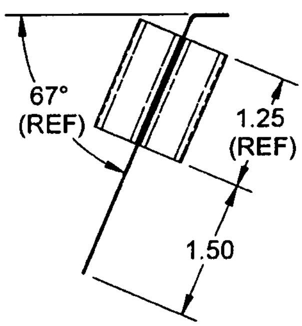
1) WELD PER DART QSI 004
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

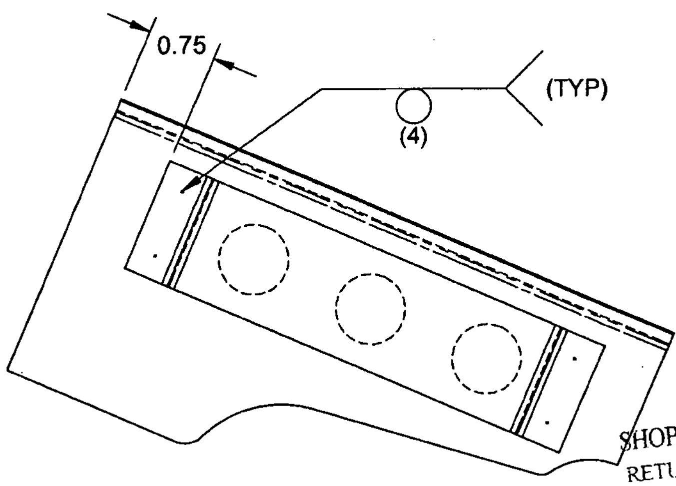
QTY -047	QTY -048	P/N	DESCRIPTION
X		**D3467-047**	**COVER PLATE ASSEMBLY, L/H**
	X	**D3467-048**	**COVER PLATE ASSEMBLY, R/H**
1		D3467-1	COVER PLATE, L/H
	1	D3467-2	COVER PLATE, R/H
1	1	D3467-7	SEAL STRIP

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3467	REV. B SHEET 5 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

DART







D3467-049 BAFFLE & DEFLECTOR ASSEMBLY

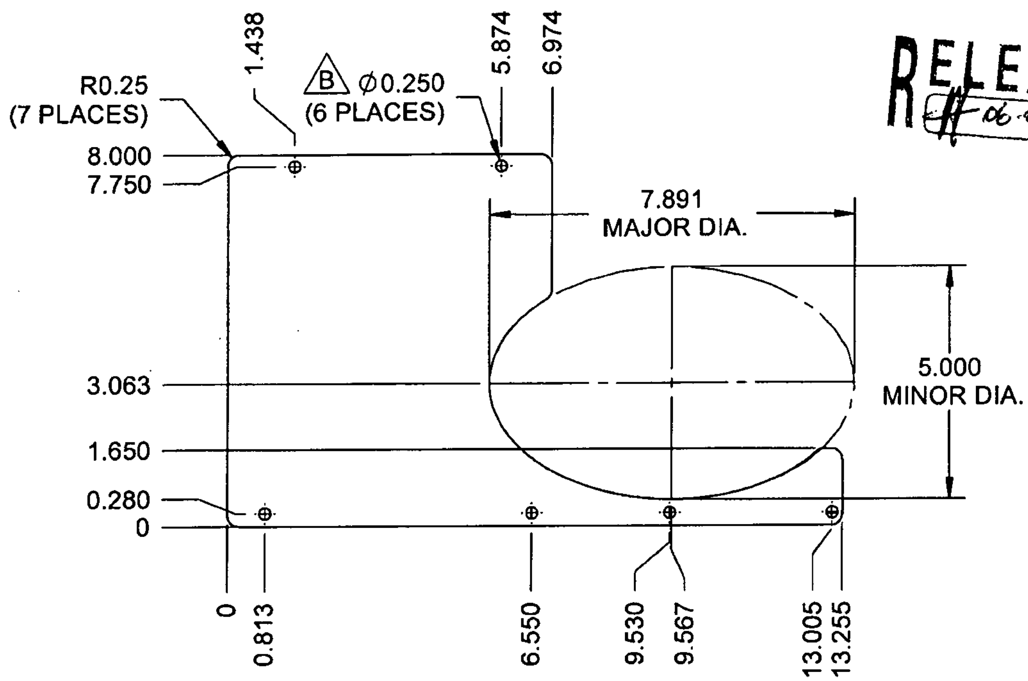
NOTES:

1) SPOT WELD PER DART QSI 004
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018
   UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

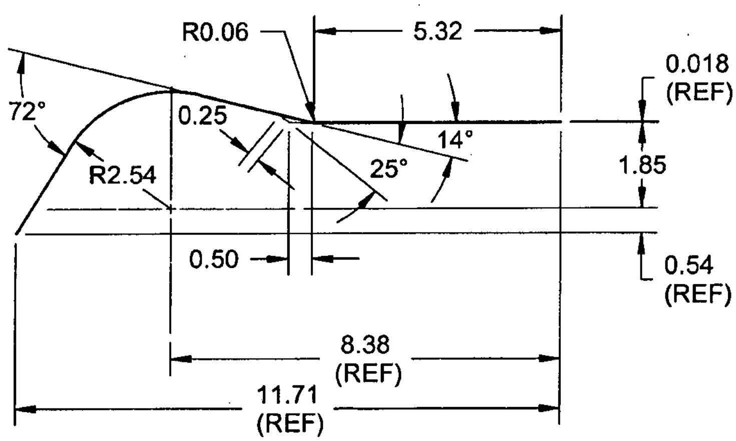
QTY -049	P/N	DESCRIPTION
	D3467-049	**BAFFLE & DEFLECTOR ASSEMBLY**
1	D3467-13	BAFFLE
2	D3467-15	DEFLECTOR

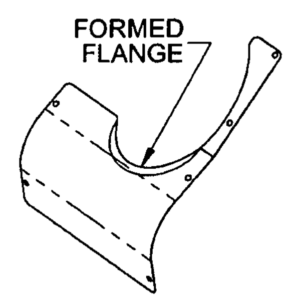
DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3467 — REV. B — SHEET 6 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY — SCALE 1:4

RELEASED 06.05.15



D3467-1F COVER PLATE FLAT PATTERN





D3467-1 L/H COVER PLATE ISOMETRIC VIEW, D3467-2 R/H COVER PLATE (OPPOSITE)

SCALE 1:8

D3467-1 L/H COVER PLATE
D3467-2 R/H COVER PLATE (OPPOSITE)

NOTES:

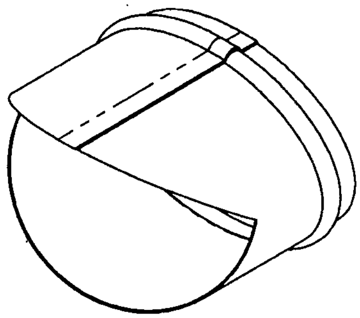
1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
   26 GAUGE SS (0.018 THICK)
   (REF. DART SPEC. M304S26GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

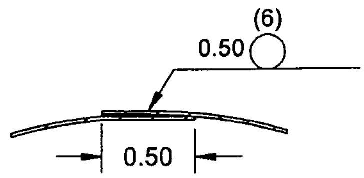
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32033

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3467 — REV. B — SHEET 7 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY — SCALE 1:2

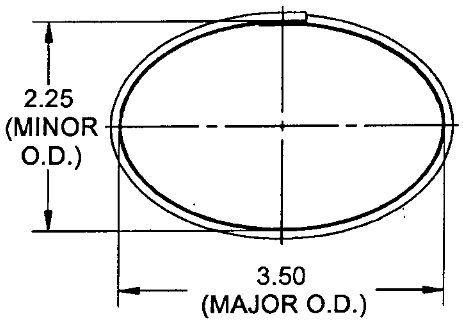
DART

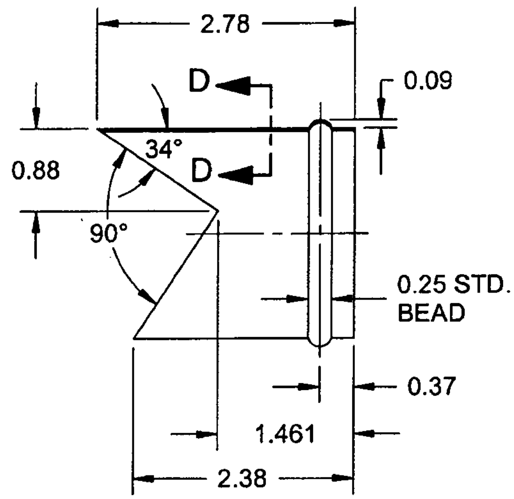
RELEASED 06.05.15



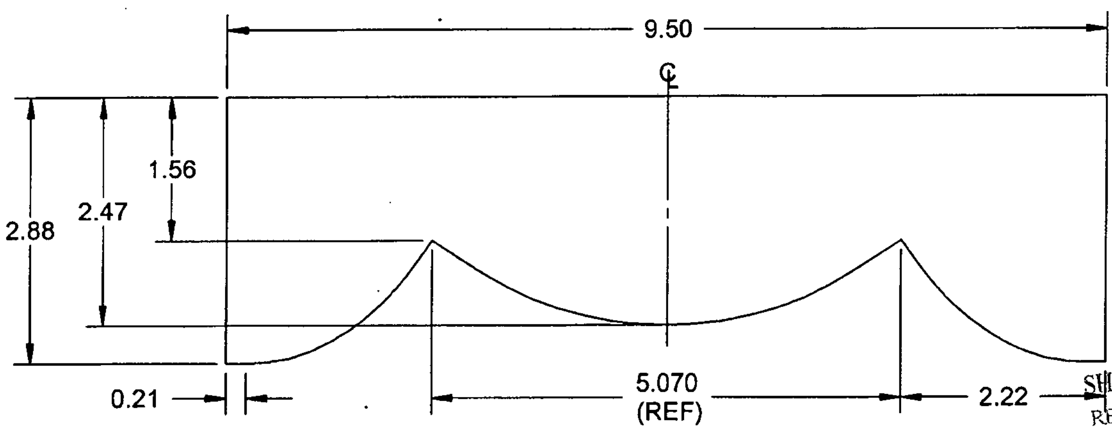


SECTION D-D
SCALE 1:1





D3467-3 TUBE DETAIL



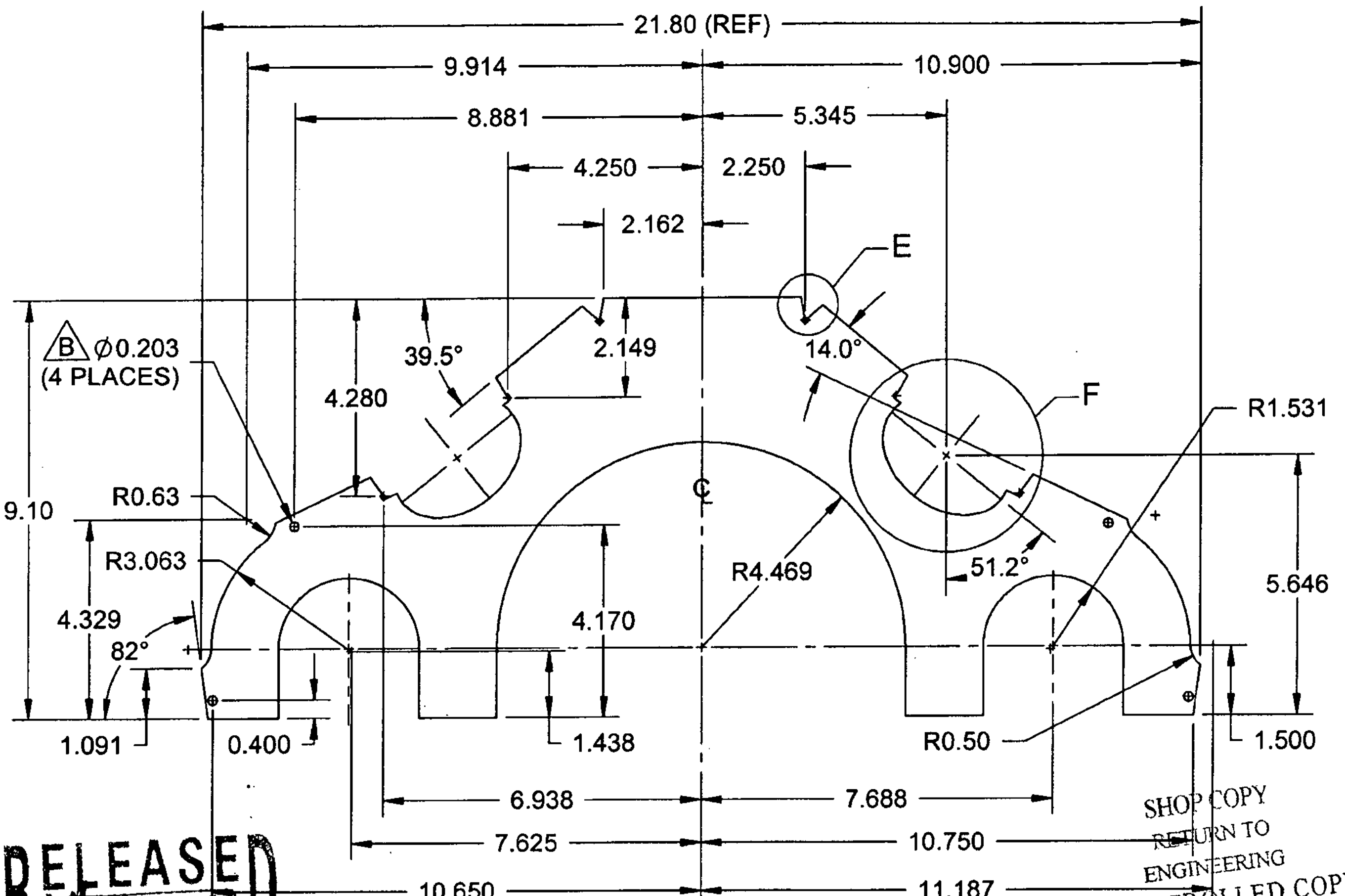
D3467-3F TUBE FLAT PATTERN

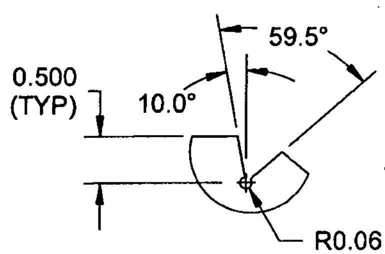
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32033

NOTES:

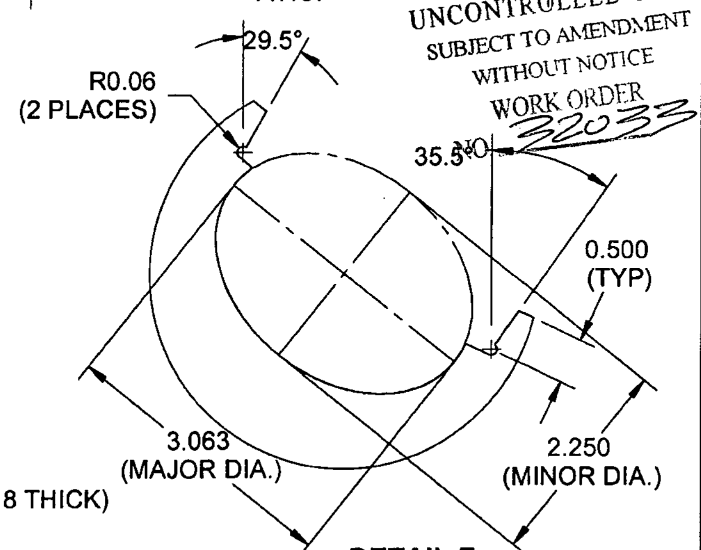
1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
   26 GAUGE SS (0.018 THICK)
   (REF. DART SPEC. M304S26GA)
2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
3) SPOT WELD PER DART QSI 004
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3467 — REV. B — SHEET 8 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY — SCALE 1:8





DETAIL E
SCALE 1:2



DETAIL F
SCALE 1:2

D3467-5F AFT PLATE FLAT PATTERN

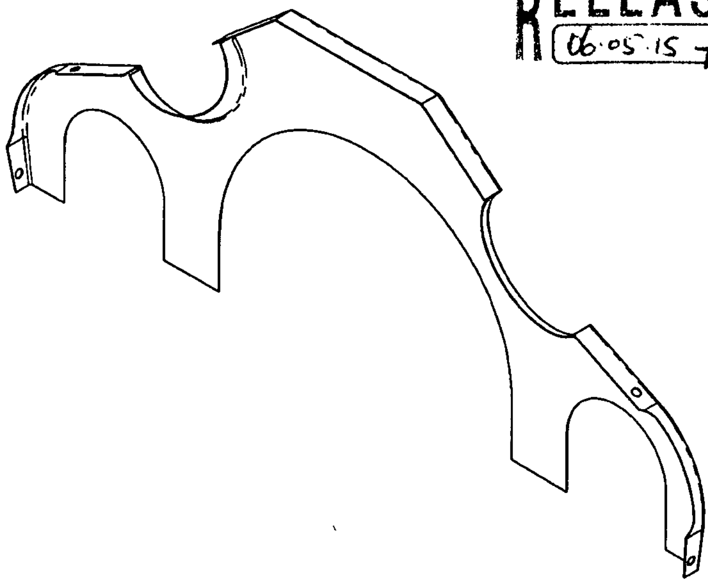
NOTES:

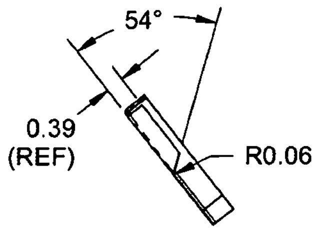
1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019
   (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK)
   (REF. DART SPEC. M304S26GA)
2) PART IS SYMMETRICAL ABOUT CENTERLINE
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3467 — REV. B — SHEET 9 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY — SCALE 1:4

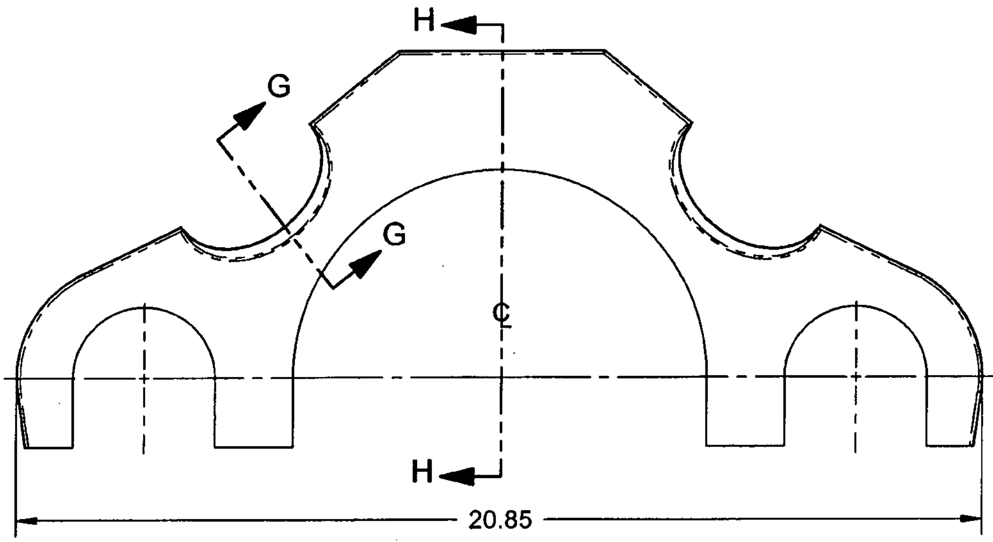
DART

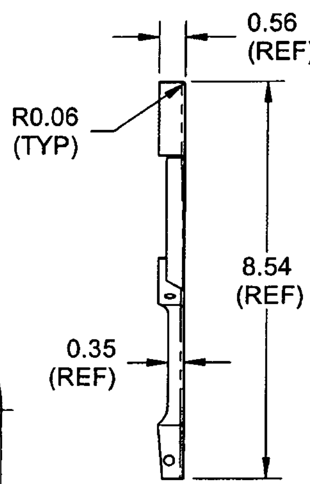
RELEASED 06.05.15





SECTION G-G





SECTION H-H

D3467-5 AFT PLATE BENDING DETAIL

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 32033

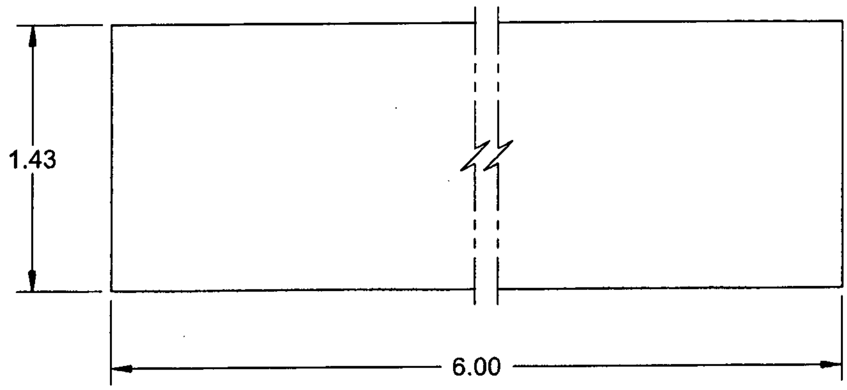
NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) ALL DIMENSIONS ARE IN INCHES
3) BREAK ALL SHARP EDGES 0.005 TO 0.010

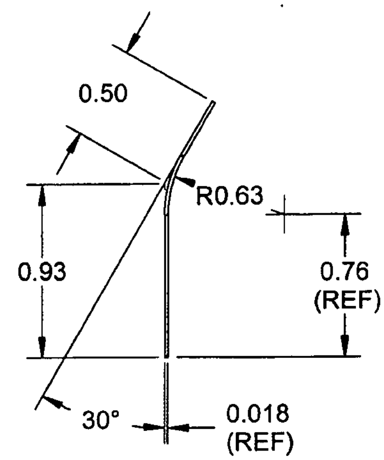
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3467 REV. B SHEET 10 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY SCALE 1:1

DART

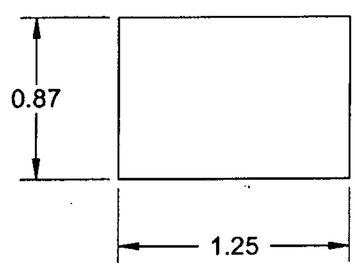
RELEASED 06.05.15



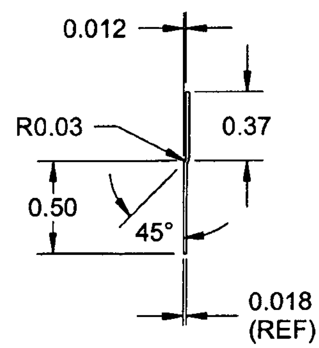
D3467-7F SEAL STRIP FLAT PATTERN



D3467-7 SEAL STRIP BENDING DETAIL



D3467-11F BRACKET FLAT PATTERN



D3467-11 BRACKET JOGGLE DETAIL

NOTES:

1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY RETURN TO ENGINEERING

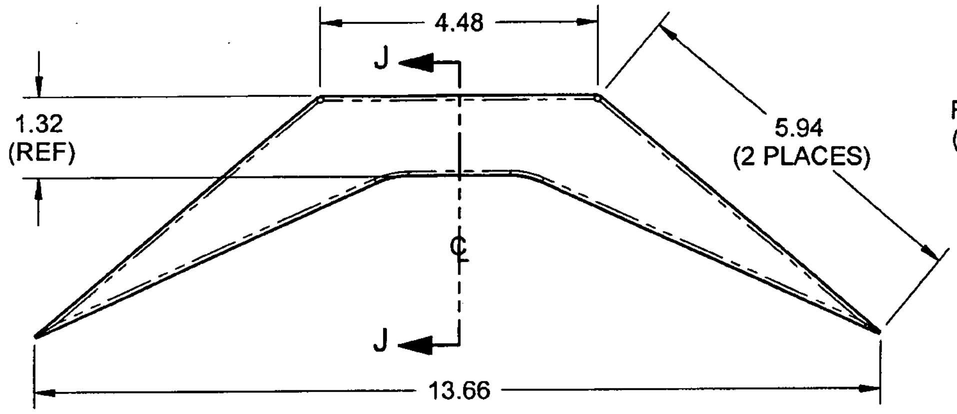
UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER NO. 32033

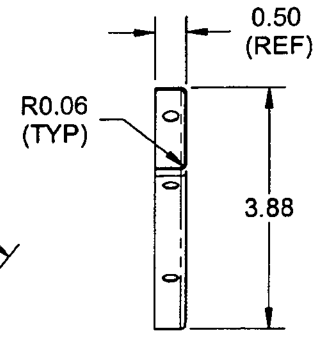
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3467 — REV. B — SHEET 11 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY — SCALE 1:3

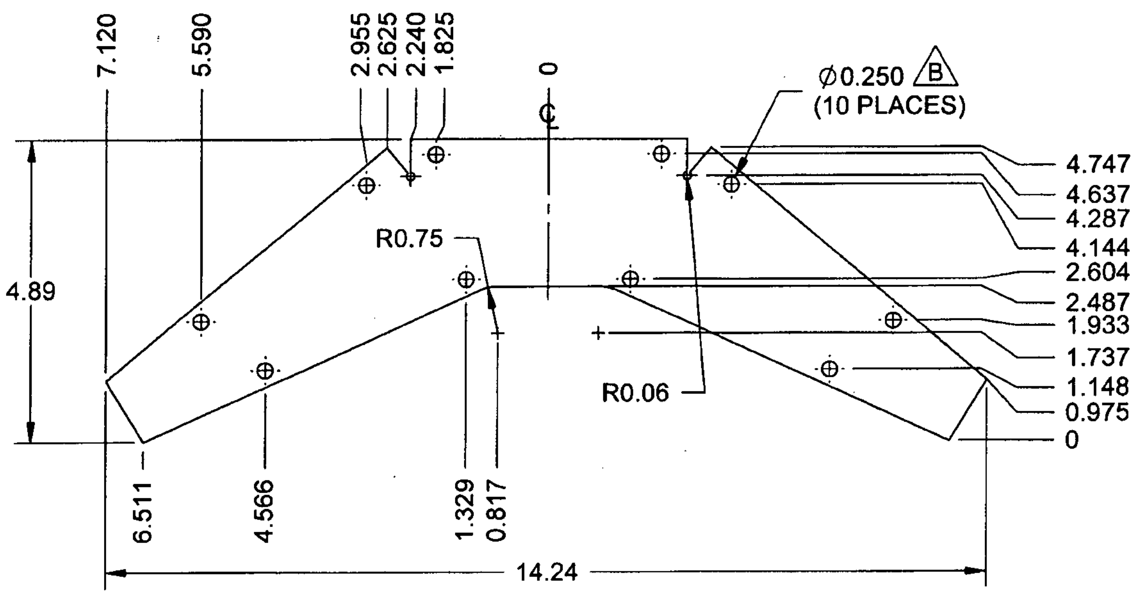
RELEASED 06.05.15



D3467-9 FWD PLATE BENDING DETAIL



SECTION J-J



D3467-9F FWD PLATE FLAT PATTERN

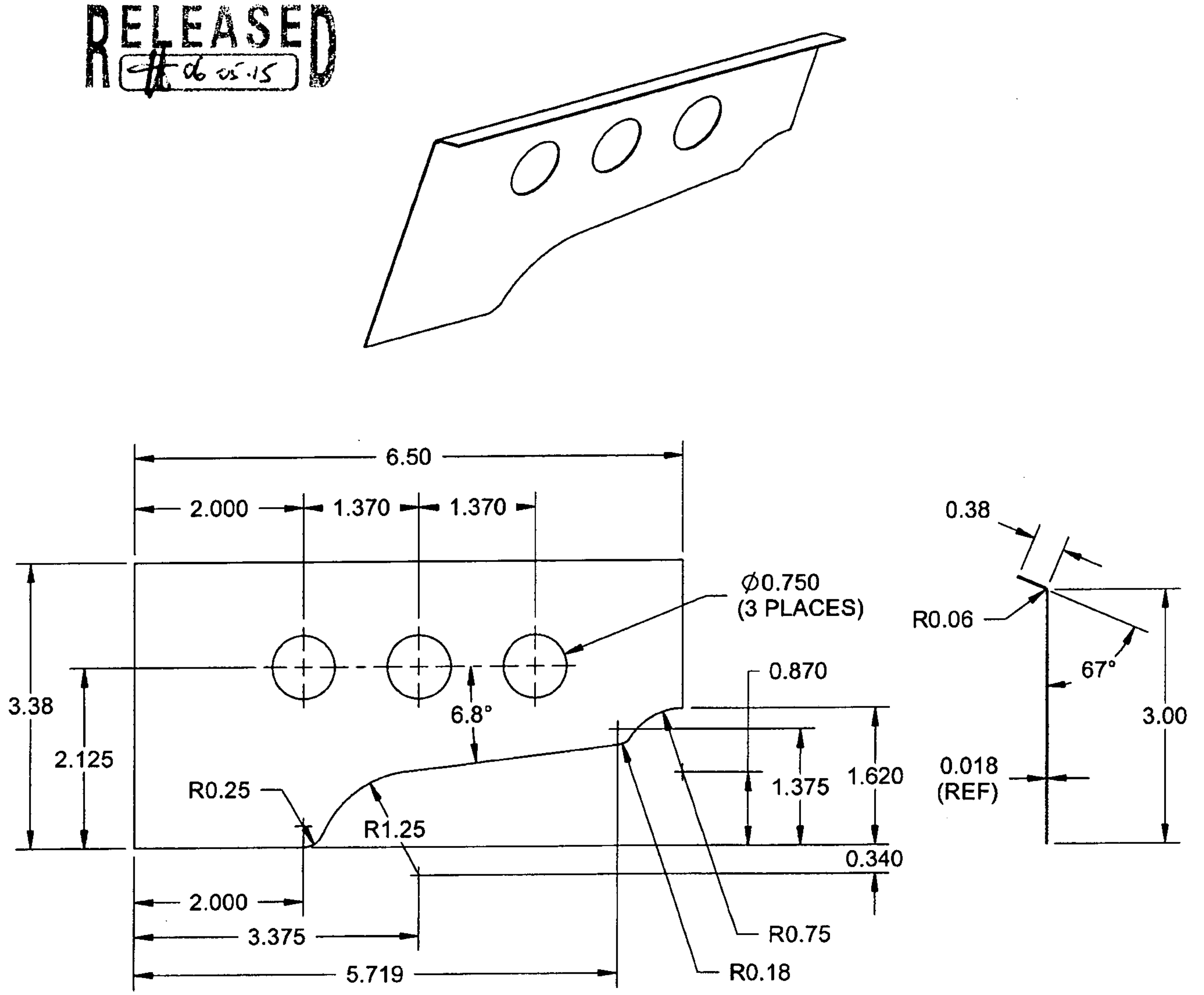
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WORK ORDER
NO. 32033

NOTES:

1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
2) PART IS SYMMETRICAL ABOUT CENTER LINE
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3467 REV. B SHEET 12 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY SCALE 1:2

RELEASED 06.05.15



D3467-13F BAFFLE FLAT PATTERN

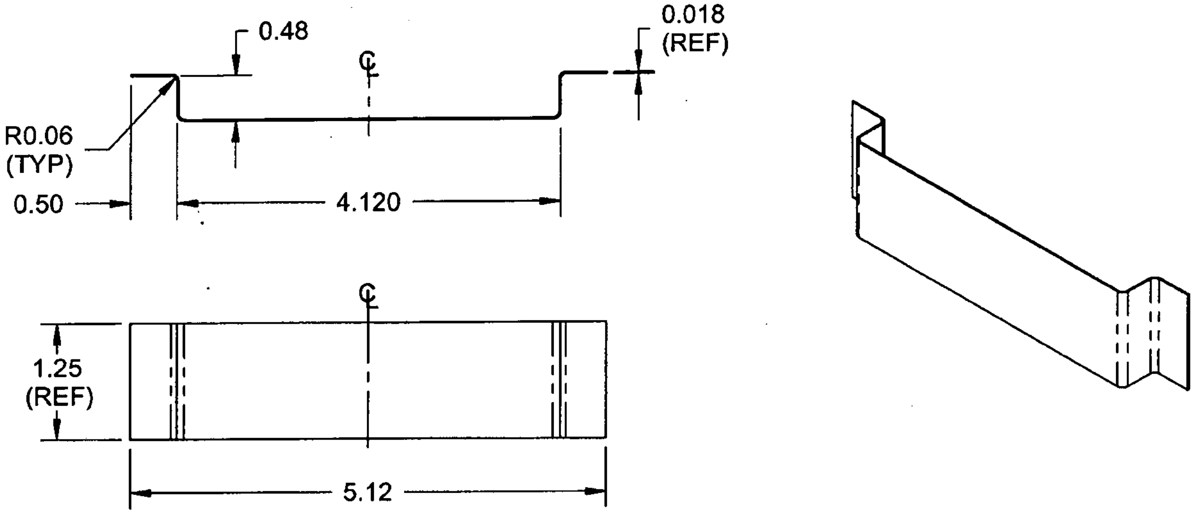
D3467-13 BAFFLE BEND DETAIL

NOTES:

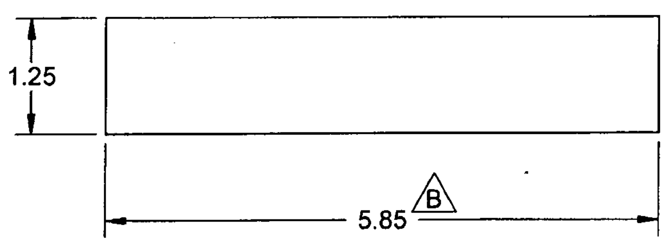
1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
   26 GAUGE SS (0.018 THICK)
   (REF. DART SPEC. M304S26GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DART

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
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DATE 06.05.15		TITLE SHROUD ASSEMBLY — SCALE 1:2



D3467-15 DEFLECTOR BENDING DETAIL

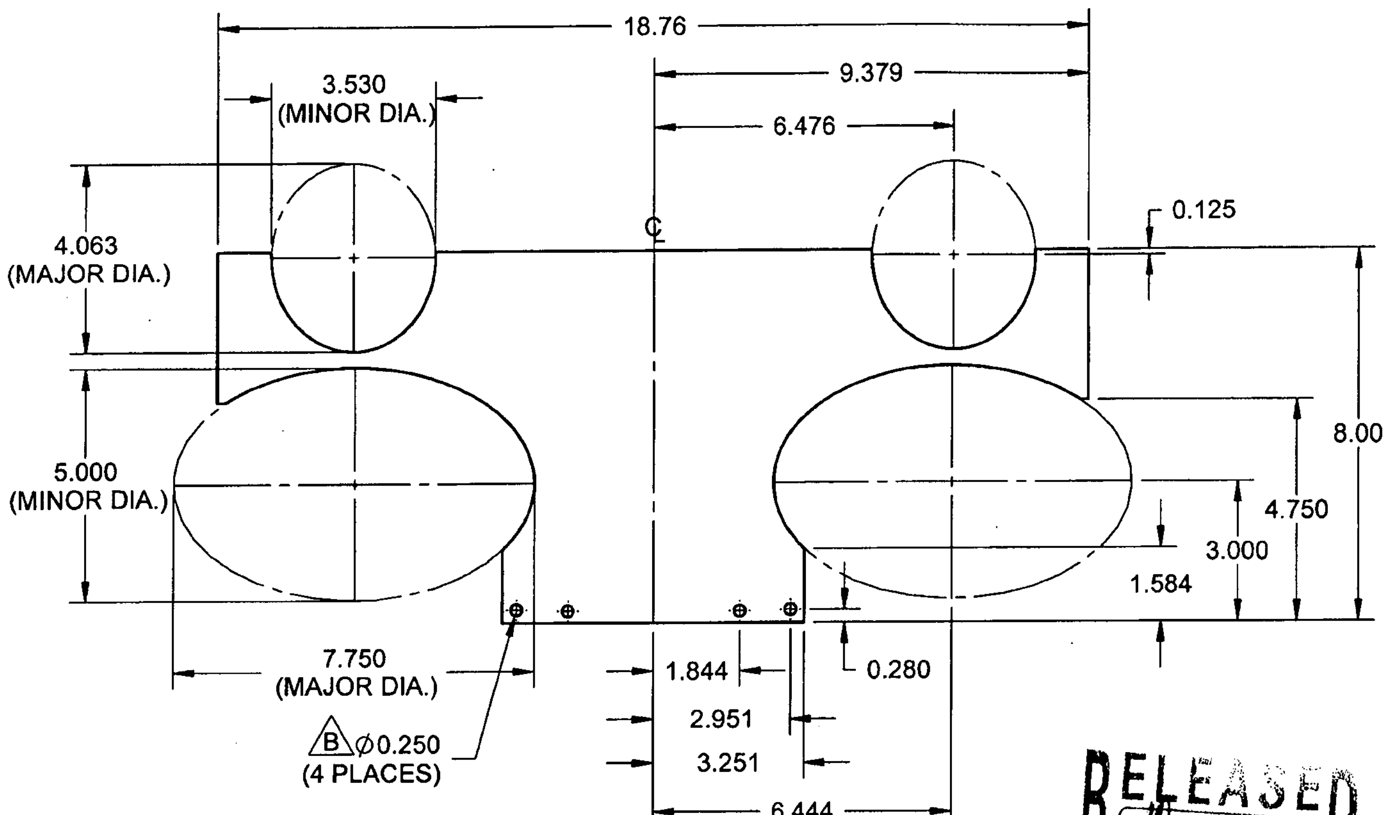


D3467-15F DEFLECTOR FLAT PATTERN

NOTES:

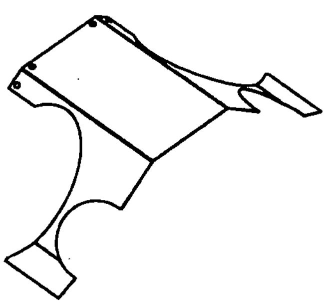
1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
   26 GAUGE SS (0.018 THICK)
   (REF. DART SPEC. M304S26GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

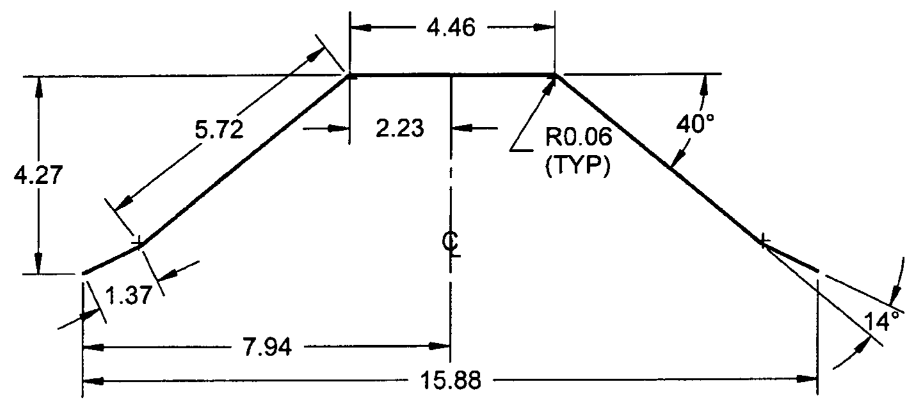
DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3467 — REV. B — SHEET 14 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY — SCALE 1:4



RELEASED 06.05.15

D3467-17F TOP COVER FLAT PATTERN





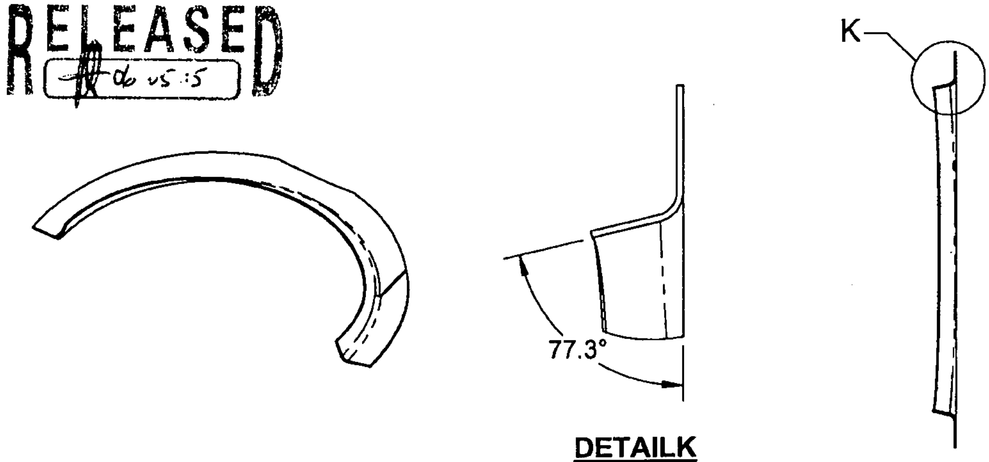
D3467-17 TOP COVER BENDING DETAIL

NOTES:

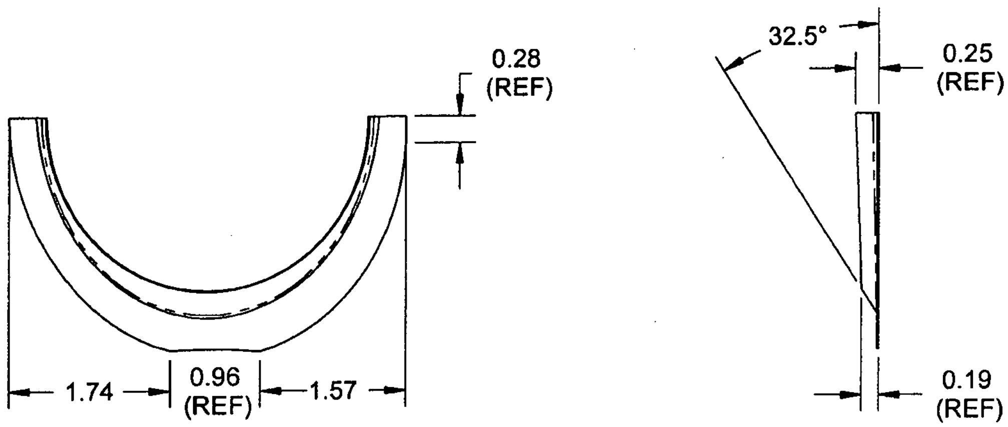
1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
   26 GAUGE SS (0.018 THICK)
   (REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT CENTERLINE
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3467	REV. B SHEET 15 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

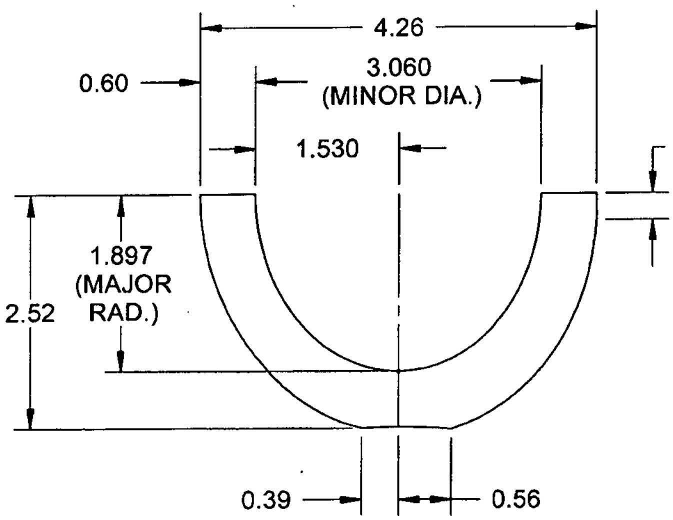
DART



DETAILK
SCALE 1:2



D3467-19 DOUBLER, L/H SHOWN
D3467-20 DOUBLER, R/H OPPOSITE



D3467-19F FLAT PATTERN

NOTES:

1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010